Date:

Wednesday, 03/09/2008 8:52:11 AM

User:

Julie Lecocq

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 41707

Estimate Number

: 10513

P.O. Number

This Issue

: 03/09/2008

: NC Prsht Rev.

First Issue **Previous Run** : // : 36298

: MACHINED PARTS 'Type

S.O. No. :

Part Number

Drawing Name

: D28052

: STOP

Drawing Number

: D2805 REV. B

Project Number : B

: N/A

Drawing Revision

Material **Due Date**

: 15/09/2008

Qty:

20 Um:

Each

Written By

Checked & Approved By

Comment

B 00.11.14

Revised Finishing step to Acid etch and

Alodine EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061-T6 Bar 1.50 x 1.50

M6061T6B1500X01500 1.0

Comment: Qty.:



🗼 5.5125 f(s) 0.2756 f(s)/Unit Total: 6061-T6 Bar 1.5" x 1.5"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5"

(M6061T6B1500X01500)

Batch: 107240

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut Bar: 3.150" Long

+0.010/-0.030"

MME

HAAS CNC VERTICAL MACHINING #1

3.0

HAAS1



- 1- Machine as per Folio FA104 and Dwg D2805
- 2- Tumble and Deburr

Identify as D2805-2

INSPECT PARTS AS THEY COME OFF

4.0 QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK



08/09/05



Page 1

Form: rprocess

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W/O:			WC	RK ORDER CHANG	iES	 				
DATE	STEP	PRO	OCEDURE CHAI	NGE	By Date Qty				Approval Chief Eng / Prod Mgr Approv QC Inspec	
l		• .								
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	'es N	o DQ	A:	Date:	
	R	lesolution:	Disposition	າ:	_ QA: N/	C Clos	sed:		Date: _	· .
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	ICR)				
5.75		Description of NC		Corrective Action Sect	tion B		Verific	eation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Si	gn & Date		Chief Eng	QC Inspector	
							;			
					·					

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 8:52:11 AM User: -Julie Lecocq **Process Sheet Drawing Name: STOP** Customer: CU-DAR001 Dart Helicopters Services Part Number: D28052 Job Number: 41707 Job Number: Description: Seq. #: **Machine Or Operation:** HAND FINISHING RESOURCE #1 HAND FINISHING1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 QC3 7.0 Comment: INSPECT ALODINE 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

W 08.09.08

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	-								
W/O:			WO	RK ORDER CHANG	ES	•			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·	-						
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Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	\ :	Date: _	
	Re	solution:	Disposition	:	_ QA: N/C C	losed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	7)			
	0==0	Description of NC			on B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Section		Chief Eng	QC Inspector
						•			
				·					
	1		t 1		L L	I .		1	1

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41707
Description: Stop	Part Number:	D2805-2
Inspection Dwg: D2805 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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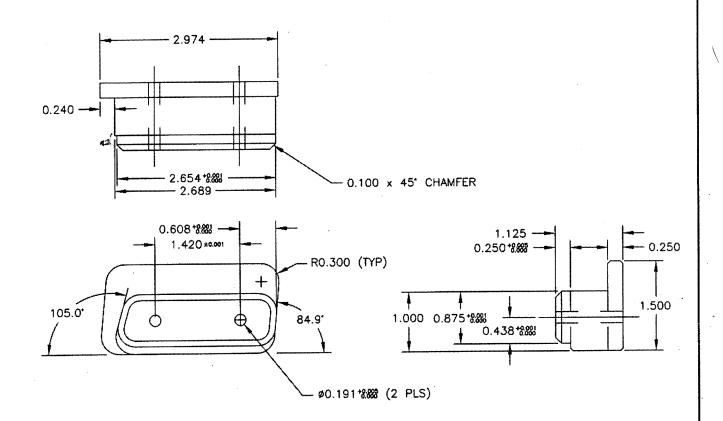
Dunning Astrol								
Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments		
Dimension		Dimension		_	inspection			
2.974	+/-0.010	2975						
0.240	+/-0.010	,240						
0.100 chamfer	+/-0.010	,100						
1.420	+/-0.001	1. 128						
1.125	+/-0.010	1.128						
0.250	+0.005/-0.000	1253			•			
0.250	+/-0.010	241						
1.500	+/-0.010	1.500						
1.000	+/-0.010	-8748						
0.875	+0.001/-0.000	-8748						
0.438	+0.001/-0.000	.4385						
		i						
					·			

Measured by:	Audited by: J.F.	Prototype Approval:	N/A
Date: 08/09/07	Date: 08/09/07	Date:	N/A

Rev	Date	Change	Revised by	P- P-7	ox/ed
Α	05.04.26	New Issue	KJ/JLM of	911	Z_{-}
				, ,	,



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	CHECK	ED.	APPROVED	DRAWING NO.	REV. B
		#	- #	D2805	SHEET 1 OF 2
	DATE			TITLE	SCALE
	01.0	3.13		STOP	2:3
	Α		00.10.31	NEW ISSUE	
	В		01.03.13	ADD $-3/-4$	



D2805-1 (SHOWN) D2805-2 (OPPOSITE)

SHOP COPY RETURN TO

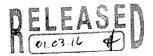
ENGINEERING BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED. BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED UNCONTROLLED MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

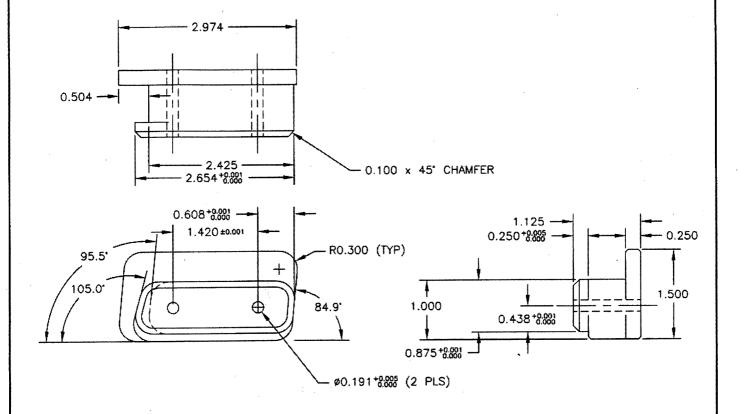
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DESIGN	DRAWN BY		ROSPACE LTD y, ontario, canada
CHECKED,	APPROVED	DRAWING NO.	REV. B
af	#	D2805	SHEET 2 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3





D2805-3 (SHOWN) D2805-4 (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO **ENGINEERING**

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTEDICONTROLLED COPY BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED, SUBJECT TO AMENDMENT MATERIAL 6061 TE (00 1 000 (0) 00 (0) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) FINISH: CHEMICAL CONVERSON COAT PER DART QSI 005 4.1

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